



Dart Hawkesbury
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

D4635-141
Job Sheet 167079-D



Part No: D4635-141

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	<i>SM</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	<i>D.M.L 17-12-27</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	<i>D.M.L 17-12-27</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>10-17-12-27</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>D.M.L 17-12-27</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>AS</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <i>S026572</i>	D4635-1 <i>S026572</i>	1	1	0	0
	D4669-1	2	27	0	0
	D4695-041 <i>S022637</i>	1	0	0	0
	D4732-29 <i>S022635</i>	1	5	0	0
	D4732-33 <i>S022633</i>	1	4	0	0
	D4732-5 <i>S022632</i>	1	5	0	0
	D4732-9 <i>S022630</i>	1	3	0	0
	D5022-1 <i>S025263</i>	1	4	0	0
	MPNY-750S-9-C <i>S022627</i>	7	570	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		 Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
Date : _____		Step #: _____		Mfg Date: 12/20/17 Job No: 167079 - D					
Description Work Order Deviation									
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dar ☐ Inspection I ☐ Contaminat ☐ Countersink ☐ Cut Too Sho ☐ Instructions I ☐ Drill Holes ☐ </td> </tr> </table>		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature ☐ Set-up ☐ BOM/Route ☐ Broken/Dar ☐ Inspection I ☐ Contaminat ☐ Countersink ☐ Cut Too Sho ☐ Instructions I ☐ Drill Holes ☐	 S025737 Fwd Ceiling Replacement Panel Assembly, LH	
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OTHER : _____		D4635 - 141 Packaging		PART NO: Revision: Operation: Change No:					